Work Order ID 66898

Wednesday, March 02, 2011 11:43:19 AM

Item ID: D2873-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Nut Plate Assembly

Start Date: 3/2/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 3/16/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** CL **Date:** 11/03/02 **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2873 / Rev A									
100	BAND SAW	0.00							
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 3.700" long	SL 11/03/03				20			
110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev AA	SL 11/03/08				20			
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control		SL 11/03/08				20			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC			B.A	11/03/09		20	ϕ		
Quality Control	**Memo**	0.00							
140		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
	1-Deburr □2- C'sink as per Dwg D2873								
150	QC5- Inspect part completeness to step on W/O	0.00							
QC			11/03/09						
Quality Control	**Memo**	0.00							

11/03/09 (20)

counted (+20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Required Date: 3/16/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				20		RK 11-3-10.	
HandFinish	**Memo**	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00				ML	11	03	10 (20)
QC	**Memo**	0.00							
Quality Control									
180		0.00				EJS 11/03/10 (20)			
Small Fab	Small Fab								
	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 ☐2-Identify as D2873-043								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
QC			SB 11/03/10			20			
Quality Control	**Memo**	0.00							
200	Identify as per dwg & Stock Location:_____	0.00							
Packaging						11/3/10	200		
Packaging	**Memo**	0.00							
210	QC21- Final Inspection - Work Order Release	0.00							
QC							11/3/11		
Quality Control	**Memo**	0.00							

MF
11-03-10

Picklist Print

Wednesday, March 02, 2011 11:43:16 AM

Work Order ID: 66898

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 3/2/2011 **Required Date:** 3/16/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5		Purchased	No			100	Each	186.0000	3	60			
Nut Plate													
				Location			**Loc Qty**		**Loc Code**				
				ST303			186						
					116741		86			46			
					116914		100			14			
M6061T6B0.375X01.00 0		Purchased	No			180	f	36.4967	0.3083	6.490526			
6061T6 BAR .375 x 1.00													
				Location			**Loc Qty**		**Loc Code**				
				MAT			36						
					113325		0						
					116963		36			6.5			
				MAT01			0.45						
					113325		0.45						
				MAT04			0.0467						
					114352		0.0467						
MS20426AD4-6		Purchased	No			180	Each	1,791.000	6	120			
Rivet													
				Location			**Loc Qty**		**Loc Code**				
				ST317			1791						
					110139		1791			120			

Dart Aerospace Ltd

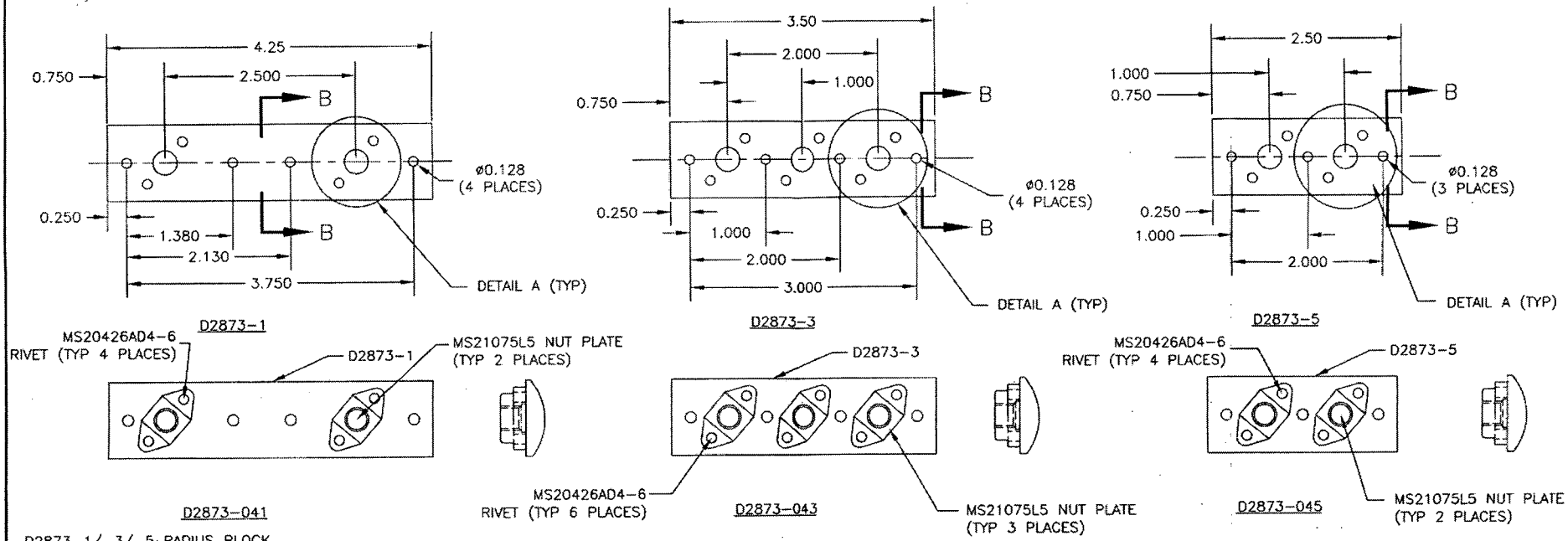
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

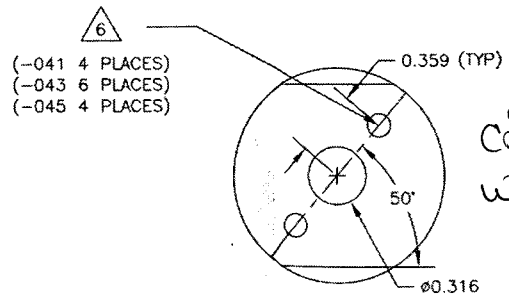
1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR
6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE INCHES
5) BREAK ALL SHARP EDGES 0.010 TO 0.020
6) ø0.128 PILOT + C'BORE CURVED SIDE ø0.230X0.125 DEEP + C'SINK CURVED SIDE ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

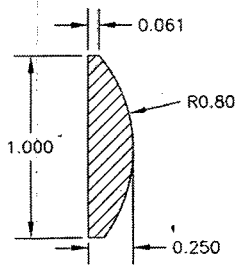
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)

CL11103/02
W10: 66898



SECTION B-B (SCALE 2:5)

RELEASED 05.07.26

A	05.07.26	NEW ISSUE	
DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873	REV. A SHEET 1 OF 1
DATE 05.07.26		TITLE RADIUS BLOCK	SCALE 4:5

DART AEROSPACE LTD	Work Order:	660898
Description: Radius Block	Part Number:	D2873-3
Inspection Dwg: D2873 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Vern. JL-3	
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.128	✓			
0.359	+/-0.010	.358	✓			
Ø0.316	+0.006/-0.001	.316	✓			
1.000	+/-0.010	1.005	✓			
0.250	+/-0.010	.242	✓			
0.061	+/-0.010	.053	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230X.129	✓			

Measured by:	JL	Audited by:	D.A	Prototype Approval:	N/A
Date:	11/03/08	Date:	11/03/09	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	06.08.30	New Issue	P/O D2873-043	KJ/JLM	